

Date: Monday, 6/25/2007 9:10:39 AM  
 User: Kim Johnston

## Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services	Drawing Name	: BRACKET
Job Number	: 33122		
Estimate Number	: 11181		
P.O. Number	: <u>N/A</u>	Part Number	: D32941
This Issue	: 6/25/2007 S.O. No. : <u>NA</u>	Drawing Number	: D3294 REV A1
Prsht Rev.	: NC	Project Number	: N/A
First Issue	: <u>N/A</u> Type : SMALL /MED FAB	Drawing Revision	: A1
Previous Run	: 32747	Material	: <u>N/A</u>
Written By	: <u>JA 07.06.25</u>	Due Date	: 7/12/2007
Checked & Approved By	: <u>JA 07.06.25</u>	Qty:	20 Um: Each
Comment	: Est A 04.08.24 New issue KJ/JLM Est Rev:B Now On Waterjet 07-03-26 JLM		

## Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	M2024T3S080	2024-T3 .080 sheet
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Comment: Qty.: 2.1072 sf(s)/Unit Total : 42.1449 sf(s)

Material: 2024-T3 (QQ-A-250/4) 0.080" thick  
 (M2024T3S.080)

Identify for D3294-1

Batch: M104921

IB 07-07-09

2.0	WATER JET	FLOW WATER JET
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Comment: FLOW WATER JET

1-Cut as per Dwg D3294

Dwg Rev: A1

Prog Rev: A1

2-Deburr if necessary and open holes.

IB 07-07-09

3.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
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Comment: INSPECT PARTS AS THEY COME OFF MACHINE

4.0	QC8	SECOND CHECK
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Comment: SECOND CHECK

07/07/18 (x2)

5.0	SMALL FAB 1	SMALL & MEDIUM FAB RESOURCE 1
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Comment: SMALL & MEDIUM FAB RESOURCE 1

Deburr

07/07/18 (x2)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: D Date: 01/07/03  
 QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Monday, 6/25/2007 9:10:40 AM  
User: Kim Johnston

## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: BRACKET

Job Number: 33122

Part Number: D32941

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

BRAKE NC

NC BRAKE



Comment: NC BRAKE

Form as per Dwg D3294

SB 07/07/19 (20)

7.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

En 07/07/19 (20)

8.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Chemical Conversion Coat as per QSI 005 4.1

41 07-07-19 (20)

9.0

POWDER COATING

POWDER COATING



Comment: POWDER COATING

Powder Coat Black Sandtex (Ref: 4.3.5.7) as per QSI 005 4.3

M-L 07/07/21 (20)

10.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT CHEMICAL CONVERSION COAT

7/7/23 (20)

11.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: \_\_\_\_\_

57273 7/7/23 (20)

12.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

7/7/23 (20)

Job Completion



7/7/23

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

<b>DART AEROSPACE LTD</b>		<b>Work Order:</b> 33122
<b>Description:</b> Bracket		<b>Part Number:</b> D3294-1
<b>Inspection Dwg:</b> D3294 <b>Rev:</b> A1		<b>Page 1 of 1</b>

### FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article      ☐ Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
20.01	+/-0.030	20.01	*		TM	
1.78	+/-0.030	1.78	*		VERN	
R0.38	+/-0.030	0.38	*		R.G	
R0.25	+/-0.030	.25	*		R.G	
12.97	+/-0.030	12.97	*		TM	
2.07	+/-0.030	2.07	*		VERN	
Ø0.128	+0.005/-0.000	Ø .128	*		VERN	
Ø0.141	+0.005/-0.000	Ø .141	*		VERN	
0.080	+/-0.010	.080	*		VERN	
Grain Direction	N/A					

<b>Measured by:</b> RB	<b>Audited by:</b>	<b>Prototype Approval:</b>	N/A
<b>Date:</b> 07-07-09	<b>Date:</b>	<b>Date:</b>	N/A

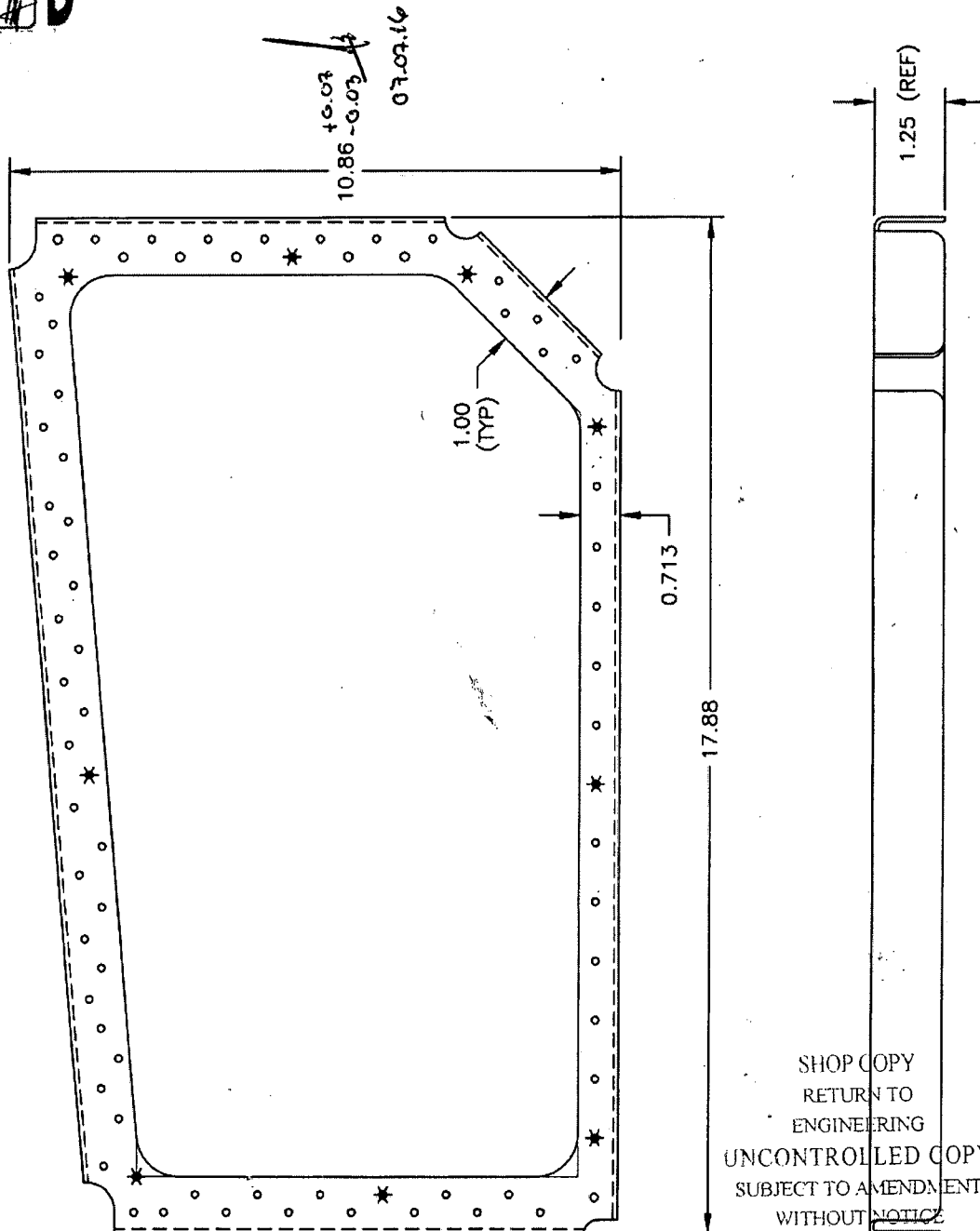
Rev	Date	Change	Revised by	Approved
A	04.08.24	New Issue	KJ/JLM	
B	06.03.09	Dimension 12.97 was 13.03	KJ/JLM	



DESIGN <i>CP</i>	DRAWN BY <i>CP</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>HH</i>	APPROVED <i>HH</i>	DRAWING NO. D3294	REV. A SHEET 1 OF 2
DATE 04.06.28		TITLE BRACKET	SCALE 1:3
A	04.06.28	NEW ISSUE	
A1	<i>CP</i> 05.06.13	12.97 WAS 13.03, AS MANUFACTURED	

RELEASED  
04.07.12

- D3294-1 BRACKET
- 1) MACHINE PER DRAWING FILE "D3294-A2.DWG"
  - 2) CHECK PER TEMPLATE D3294-1T1
  - 3) MATERIAL: 2024-T3 (QQ-A-250/4) SHEET 0.080 THICK (REF. DART SPEC M2024T3S.080)
  - 4) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1  
POWDER COAT BLACK SANDTEX (4.3.5.7) PER DART QSI 005 4.3
  - 5) USE MINIMUM BEND RADIUS OF 0.188"
  - 6) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED



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WORK ORDER  
NO. 33122

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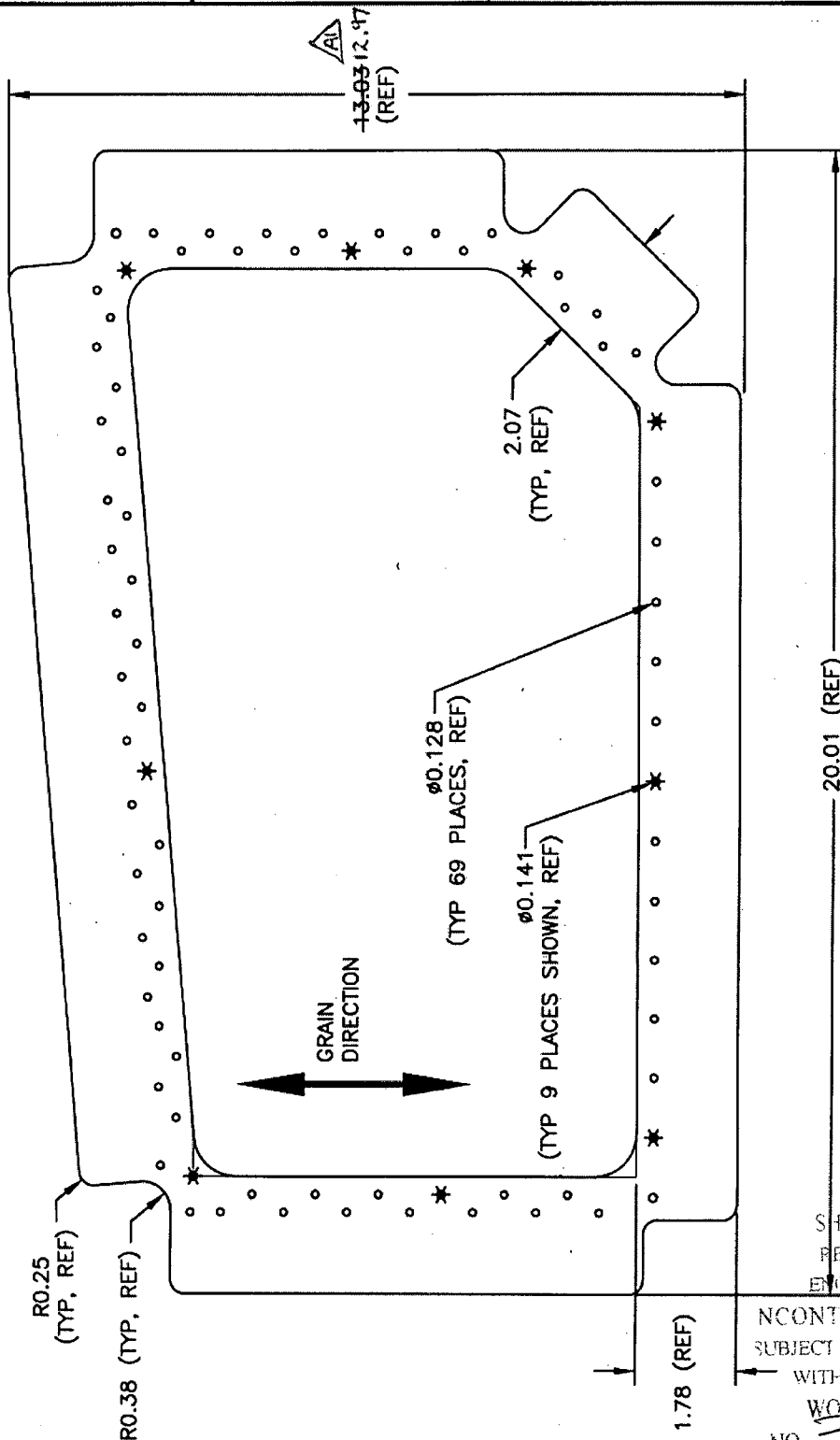
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CHECKED <i>#</i>	APPROVED <i>#</i>	DRAWING NO. D3294	REV. A SHEET 2 OF 2
DATE 04.06.28	TITLE BRACKET		SCALE 1:3

D3294-1 FLAT PATTERN

RELEASED  
09.07.12



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WORK ORDER

33122

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